

Work Order ID 153630

Wednesday, November 23, 2016 9:15:59 AM

153630

Page 1

Item ID: PB67-43001-11

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Fwd Adjustable Blade Support Assembly

Start Date: 11/23/2016 Start Qty: 1.00

1

Cust Item ID:

Required Date: 12/23/2016 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: MF Date: 10-11-23

Tooling:

Date:

Run Start

NR1

QC: Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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B67-43001-11	D
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100

Weld per dwg A/R Aluminum rod Batch: 134826

Large Fab

100

Large Fab

Memo

0.14

1- Make a 0.090" chamfer in the 1.00" hole before welding

2- Grind weld flush in area of PB67-43001-249 only

1

DEC 14 2016

DAS
24
9-89

102

0.00

102

Mill Conv

Memo

0.00

Conventional Milling Machine

DRILL AND TAP FOR 1/2"-20 HELICAL INSERT

INSTALL HELICAL INSERT

10DAS
32
9-89

16-12-19

104

Weld per dwg A/R Aluminum rod Batch: 134826

Large Fab

104

Large Fab

Memo

0.00

ASSEMBLE AND WELD AS PER DWG

1

DEC 14 2016

DAS
24
9-89

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																																																																																																																										
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<table border="1" style="width:100%; border-collapse: collapse;"> <thead> <tr> <th colspan="4" style="text-align: left;">Root Cause</th> <th colspan="8" style="text-align: left;">FAULT CATEGORY</th> </tr> </thead> <tbody> <tr> <td>Environment ☐</td> <td>☐</td> <td>No Re-verification</td> <td>☐</td> <td>Pressure/Forced</td> <td>☐</td> <td>Temperature/Cure</td> <td>☐</td> <td>Power Loss/Surge</td> <td>☐</td> <td>Positioned Wrong</td> <td>☐</td> </tr> <tr> <td>Design ☐</td> <td>☐</td> <td>Operator</td> <td>☐</td> <td>Bending</td> <td>☐</td> <td>Set-up</td> <td>☐</td> <td>Folio/Program</td> <td>☐</td> <td>Outside Dimensions</td> <td>☐</td> </tr> <tr> <td>Doc/Data ☐</td> <td>☐</td> <td>Offset/Setup</td> <td>☐</td> <td>Centre Not Concentric</td> <td>☐</td> <td>BOM/Route</td> <td>☐</td> <td>Grain</td> <td>☐</td> <td>Over/Under tolerance</td> <td>☐</td> </tr> <tr> <td>Equip/Tooling ☐</td> <td>☐</td> <td>Supplier</td> <td>☐</td> <td>Cracks</td> <td>☐</td> <td>Broken/Damage/Defect</td> <td>☐</td> <td>Weld</td> <td>☐</td> <td>Part Incorrect</td> <td>☐</td> </tr> <tr> <td>Handling/Pre ☐</td> <td>☐</td> <td>Training</td> <td>☐</td> <td>Crimp/Kink/Ripple/Wave</td> <td>☐</td> <td>Inspection Incomplete/Unqualified</td> <td>☐</td> <td>Wrong Stock Pulled</td> <td>☐</td> <td>Part Lost/Missing</td> <td>☐</td> </tr> <tr> <td>Material ☐</td> <td>☐</td> <td>Use for Testing</td> <td>☐</td> <td>Cuffs</td> <td>☐</td> <td>Contamination</td> <td>☐</td> <td>Out of Sequence</td> <td>☐</td> <td>Part Moved</td> <td>☐</td> </tr> <tr> <td>Internal Transport ☐</td> <td>☐</td> <td>Poor Information</td> <td>☐</td> <td>Crushing</td> <td>☐</td> <td>Countersink</td> <td>☐</td> <td>Off-set</td> <td>☐</td> <td>Drawing</td> <td>☐</td> </tr> <tr> <td>Tribal Knowledge ☐</td> <td>☐</td> <td>Rushing</td> <td>☐</td> <td>Heat Treat</td> <td>☐</td> <td>Cut Too Short</td> <td>☐</td> <td>Mislabeled</td> <td>☐</td> <td>Finish</td> <td>☐</td> </tr> <tr> <td>LOA ☐</td> <td>☐</td> <td>Product Improvement</td> <td>☐</td> <td>Wave/Twist in Tube</td> <td>☐</td> <td>Instructions Incomplete/Unclear</td> <td>☐</td> <td>Fit/Function</td> <td>☐</td> <td>Misread</td> <td>☐</td> </tr> <tr> <td>Substation ☐</td> <td>☐</td> <td>Process Improvement</td> <td>☐</td> <td>Marks/Chatter</td> <td>☐</td> <td>Drill Holes</td> <td>☐</td> <td>Misaligned/off center</td> <td>☐</td> <td>Turning Sequence</td> <td>☐</td> </tr> <tr> <td>Past Expiry Date ☐</td> <td>☐</td> <td>Manufacturing Process</td> <td colspan="9" rowspan="2" style="vertical-align: top;">OTHER :</td> </tr> <tr> <td>Misidentified ☐</td> <td>☐</td> <td>Past Due</td> </tr> </tbody> </table>												Root Cause				FAULT CATEGORY								Environment ☐	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong	☐	Design ☐	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions	☐	Doc/Data ☐	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance	☐	Equip/Tooling ☐	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect	☐	Handling/Pre ☐	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing	☐	Material ☐	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved	☐	Internal Transport ☐	☐	Poor Information	☐	Crushing	☐	Countersink	☐	Off-set	☐	Drawing	☐	Tribal Knowledge ☐	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	Finish	☐	LOA ☐	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread	☐	Substation ☐	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence	☐	Past Expiry Date ☐	☐	Manufacturing Process	OTHER :									Misidentified ☐	☐	Past Due
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Work Order ID 153630

Wednesday, November 23, 2016 9:15:59 AM

153630

Page 2

Item ID: PB67-43001-11

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Fwd Adjustable Blade Support Assembly

Start Date: 11/23/2016 Start Qty: 1.00

1

Cust Item ID:

Required Date: 12/23/2016 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

NR1

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
105	QC5- Inspect part completeness to step on W/O	0.00							
105									
QC	Memo	0.00							DAS 9 9-89
Quality Control									
110	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
110									
QC	Memo	0.00							DAS 9 9-89
Quality Control									
160	Green Sandtex(Ref:4.3.5.8) per QSI005 4.3	0.00							
160	<i>m 134092</i>								
Powdercoat	Memo	0.01							
Powder Coating	1- MASK TUBE FROM BASE TO GUSSET								
	START TIME: <i>3:40</i>								
	OVEN TEMPERATURE: <i>320°</i>								
	FINISH TIME: <i>4:10</i>								

1 16-12-21 *DAS 9 9-89*

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐				
Date : _____	Step #: _____	QTY Effective : _____			MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			Completed By	
					Lead hand / Supervisor Approval Verification	
					QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐				
OTHER : _____						

Wednesday, November 23, 2016 9:15:59 AM

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[illegible]

DAS
9
9-89

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
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Misidentified ☐	Past Due ☐																																																																

Work Order ID 153630

Wednesday, November 23, 2016 9:15:59 AM

153630

Page 4

Item ID: PB67-43001-11

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Fwd Adjustable Blade Support Assembly

Start Date: 11/23/2016 Start Qty: 1.00

1

Cust Item ID:

Required Date: 12/23/2016 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
200	Identify as per dwg & Stock Location: <u>ME22</u>	0.00							
200									
Packaging	Memo	0.00							
Packaging									
210	QC21- Final Inspection - Work Order Release	0.00							
210									
QC	Memo	0.02							
Quality Control									

1 JAN 05 2017 *CP*DAS
21
9-89

JAN 06 2017

DAS
21
9-89

JAN 05 2017

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval 	
Description Work Order Deviation				Disposition					
								Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	

Root Cause				FAULT CATEGORY			
Environment ☐	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐
Design ☐	☐	Operator	☐	Bending	☐	Set-up	☐
Doc/Data ☐	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐
Equip/Tooling ☐	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐
Handling/Pre ☐	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐
Material ☐	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐
Internal Transport ☐	☐	Poor Information	☐	Crushing	☐	Countersink	☐
Tribal Knowledge ☐	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐
LOA ☐	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐
Substation ☐	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐
Past Expiry Date ☐	☐	Manufacturing Process	☐	OTHER :			
Misidentified ☐	☐	Past Due	☐				

Picklist Print

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Page 1

Work Order ID: 153630

153630

Parent Item: PB67-43001-11

PB67-43001-11

Parent Item Name: Fwd Adjustable Blade Support Assembly

Start Date: 11/23/2016

Required Date: 12/23/2016

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 08-06-26 new issue DD verified by:ec
10.09.27 per revC dwg EC verified by:DD

IPP Rev B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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MS124780		Purchased	No				Each	16.0000		1			
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MS124780

HELICAL INSERT

Location

Loc Qty

Loc Code

ST316

16

111064

16

MS27039-1-10		Purchased	No				Each	459.0000		8			
--------------	--	-----------	----	--	--	--	------	----------	--	---	--	--	--

MS27039-1-10

SCREW

Location

Loc Qty

Loc Code

GA

17

m129541

17

over006

300

m135774

300

ST280

142

m135603

142

NAS1149D0316J		Purchased	No				Each	1,185.000		8			
---------------	--	-----------	----	--	--	--	------	-----------	--	---	--	--	--

NAS1149D0316.J

Washer

Location

Loc Qty

Loc Code

ST264

1185

M134502

1185

MF 10-11-28

MF 10-11-28

MF 10-11-28

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



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Date :		Step #:		QTY Effective :				MRB (QSI042) Approval 	
Description Work Order Deviation				Disposition					
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Root Cause				FAULT CATEGORY							
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong	☐
Design	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions	☐
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance	☐
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect	☐
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Past Expiry Date	☐	Manufacturing Process	☐	OTHER : _____							
Misidentified	☐	Past Due	☐								

Picklist Print

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Page 2

Work Order ID: 153630

153630

Parent Item: PB67-43001-11

PB67-43001-11

Parent Item Name: Fwd Adjustable Blade Support Assembly

Start Date: 11/23/2016

Required Date: 12/23/2016

Start Qty: 1.00

Required Qty: 1.00

NAS1149D0363J

Purchased

No

Each

1,002.000

8

NAS1149D0363J******

Washer

LocationLoc QtyLoc Code

GA

364

m134055

364

ST263

638

m135864

638

Each

0.0000

1

PB67-43001-247

Manufactured

No

PB67-43001-247

Inner Tube

PB67-43001-249

Manufactured

No

Each

5.0000

1

PB67-43001-249******

Inner Tube Bushing

LocationLoc QtyLoc Code

WA003

5

133726

5

Each

4.0000

1

PB67-43001-253

Manufactured

No

PB67-43001-253

Gusset

LocationLoc QtyLoc Code

Mezz2

4

139182

3

152146

1

Each

4.0000

1

PB67-43001-254

Manufactured

No

PB67-43001-254

Gusset

LocationLoc QtyLoc Code

Mezz2

4

152077

4

Wednesday, November 23, 2016 9:15:59 AM

Shop Packet Print

Page 2

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval																																																									
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval																																																									
Root Cause		FAULT CATEGORY																																																															
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER :			
Misidentified ☐	Past Due ☐																																																																

Picklist Print

Wednesday, November 23, 2016 9:15:59 AM

Page 3

Work Order ID: 153630

153630

Parent Item: PB67-43001-11

PB67-43001-11

Parent Item Name: Fwd Adjustable Blade Support Assembly

Start Date: 11/23/2016

Required Date: 12/23/2016

Start Qty: 1.00

Required Qty: 1.00

PB67-43001-67

Manufactured No

Each

0.0000

1

PR67-43001-67

90° Blade Support Assembly

**

3152/16 → 1 Cpc

PB67-43001-69

Manufactured No

Each

3.0000

1

PR67-43001-69

90 Degree Cover Plate

**

Location

Loc Qty

Loc Code

Mezz2

3

138691

3

Each

12.0000

1

WRC 10-11-28

PB67-43001-83

Manufactured No

PR67-43001-83

D-Pad Assembly, Short

**

Location

Loc Qty

Loc Code

Mezz2

12

138687

12

WRF 10-11-28

DQA: _____ Date: _____

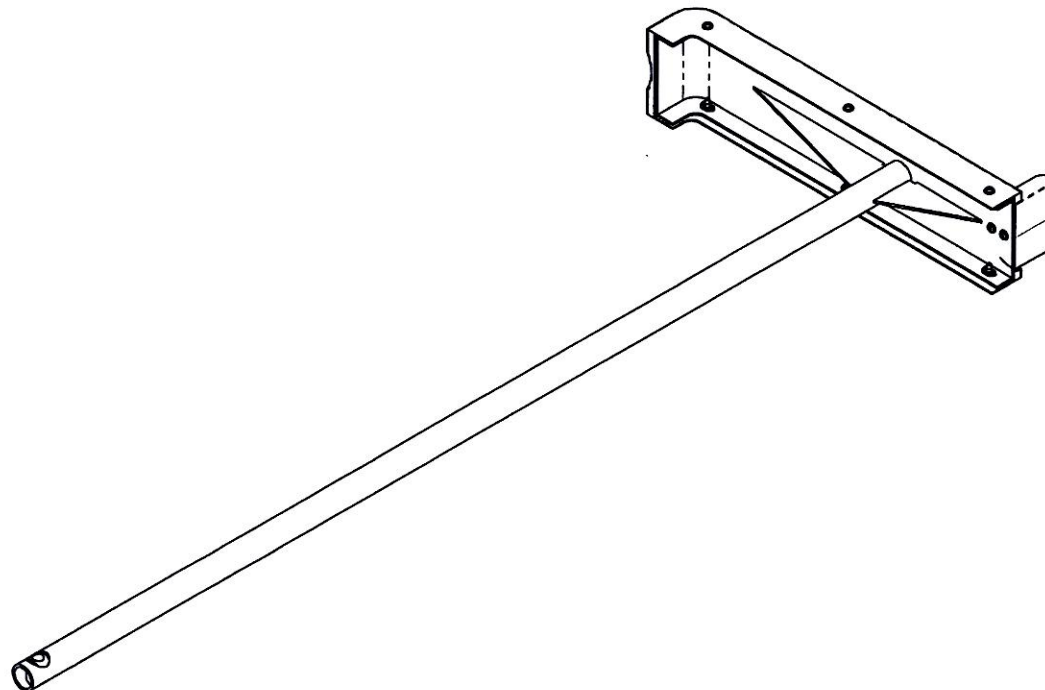
WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
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Root Cause		FAULT CATEGORY																																																															
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Misidentified ☐	Past Due ☐																																																																



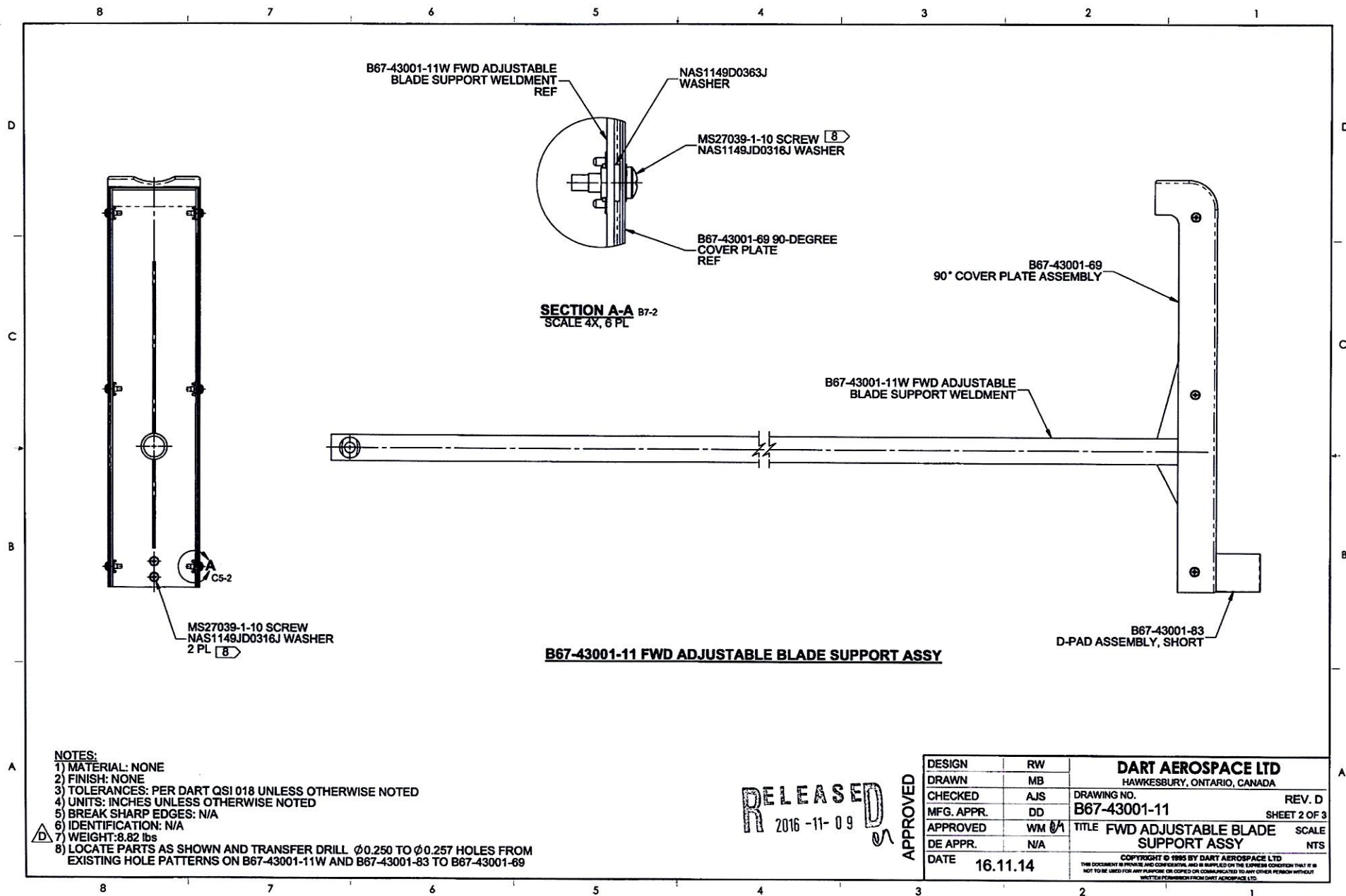
B67-43001-11 FWD ADJUSTABLE BLADE SUPPORT ASSY

RELEASED
2016-11-09
16-11-09

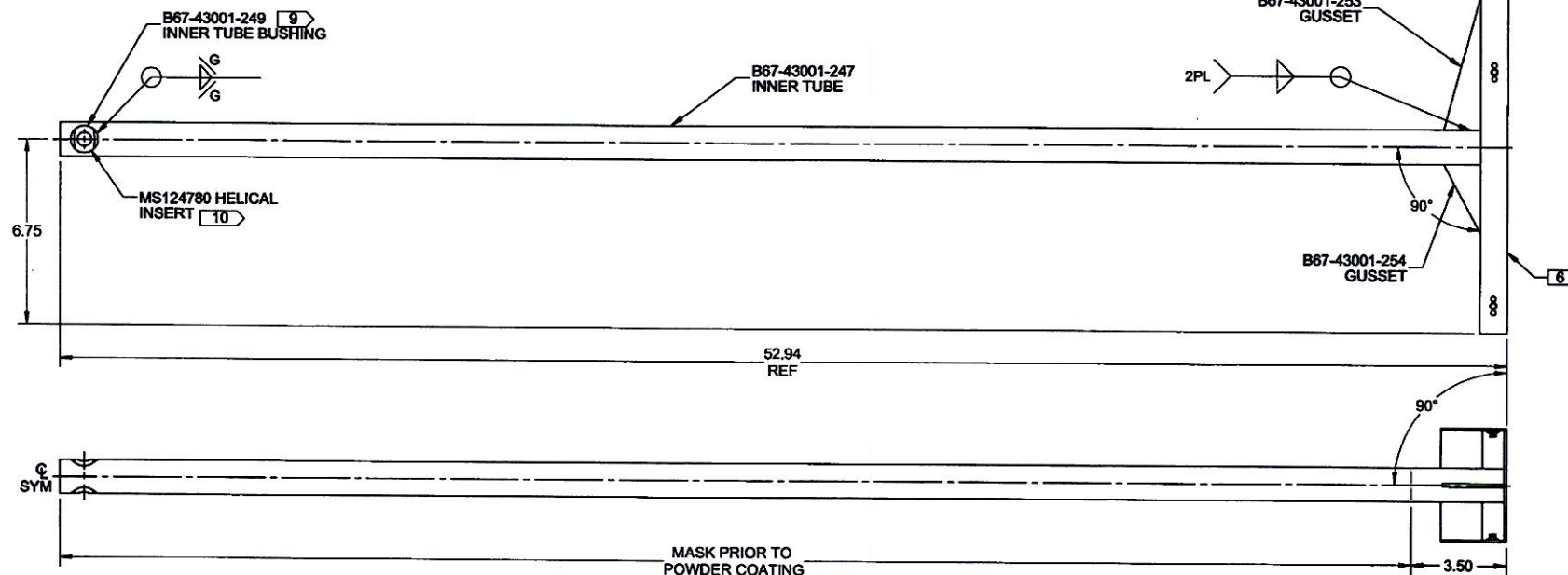
ITEM	QTY -11	P/N	DESCRIPTION
1	X	B67-43001-11	FWD ADJUSTABLE BLADE SUPPORT ASSEMBLY
2	1	B67-43001-11W	FWD ADJUSTABLE BLADE SUPPORT WELDMENT
3	1	B67-43001-69	90° COVER PLATE ASSEMBLY
4	1	B67-43001-83	SHORT D-PAD ASSY
5	8	MS27039-1-10	SCREW
6	8	NAS1149D0318J	WASHER
7	8	NAS1149D0363J	WASHER

D	MERGE B67-43001-11W WITH B67-43001-11 REASON, UPDATE WEIGHT B67-43001-11, PARTS-437	SAD	16.11.14
C	REDRAWN PREMIER AVIATION DRAWING IAW DART QSI 018 AND QSI 043. FOR PREVIOUS REVISIONS, REFER TO SHEET 8 OF PREMIER AVIATION DRAWING No. B67-43001. REASON: SEE PAR#09-011.	MB	10.04.28
REV.	DESCRIPTION	BY	DATE
DESIGN	RW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	MB		
CHECKED	AJS	DRAWING NO.	REV. D
MFG. APPR.	DD	B67-43001-11	SHEET 1 OF 3
APPROVED	WM	TITLE	SCALE
DE APPR.	N/A	FWD ADJUSTABLE BLADE SUPPORT ASSY	NTS
DATE	16.11.14	COPYRIGHT © 1986 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR OTHERWISE REPRODUCED TO ANY OTHER PERSON OR WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

APPROVED



ITEM	QTY	P/N	DESCRIPTION
1	X	B67-43001-11W	FWD ADJUSTABLE BLADE SUPPORT WELDMENT
2	1	B67-43001-67	90-DEGREE BLADE SUPPORT ASSY
3	1	B67-43001-247	INNER TUBE
4	1	B67-43001-249	INNER TUBE BUSHING
5	1	B67-43001-253	GUSSET
6	1	B67-43001-254	GUSSET
7	1	MS124780	HELICAL INSERT



B67-43001-11W FWD ADJUSTABLE BLADE SUPPORT WELDMENT

NOTES:

- 1) MATERIAL: NONE
- 2) FINISH: POWDER COAT "GREEN SANDTEX" (4.3.5.8) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "B67-43001-11W" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 3.60 lbs
- 8) WELDING: PER QSI 004
- 9) GRIND B67-43001-249 BUSHING AND WELD TO CONTOUR OF TUBE IN ACCORDANCE WITH NOTE 8
- 10) INSTALL HELICAL INSERT PER MS33537

RELEASED
2016-11-09

APPROVED

DESIGN	RW	DART AEROSPACE LTD	
DRAWN	MB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AJS	DRAWING NO.	REV. D
MFG. APPR.	DD	B67-43001-11	SHEET 3 OF 3
APPROVED	WM	TITLE	SCALE
DE APPR.	N/A	FWD ADJUSTABLE BLADE SUPPORT ASSY	NTS
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